

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028215**Date Inspected:** 21-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge**Location:** Reedsport, OR**CWI Name:** Jim Vanek**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Hnadrails**Summary of Items Observed:**

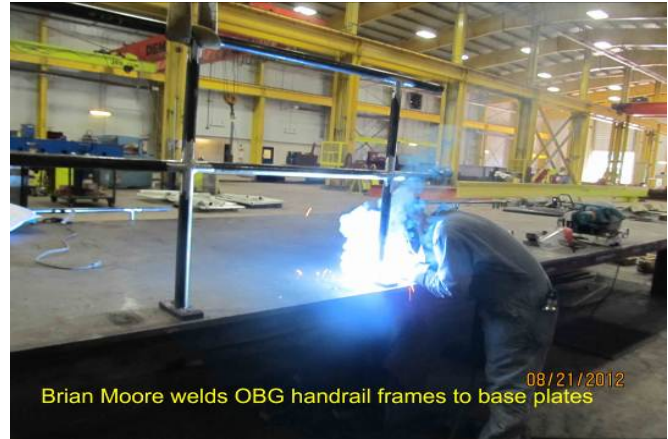
This Quality Assurance Inspector (QAI), Dan Chang, arrived at American Bridge (AB) manufacturing in response to TL-38 for CCO 189 to perform QA observations on OBG handrails performed by an AB personnel. This QAI observed Quality Control Inspector (QCI), Jim Vanek, of AB monitored welding parameters and measured dimensions of the handrails. QCI informed this QAI that amperage is 260 and voltage 26.2, using Amprobe Model ACDC-100, which is within Welding Procedure Specification (WPS) range. This QAI observed QCI monitored amperage, voltage, and joint fit-up. Additionally, this QAI randomly verified joint fit-up, amperage, and voltage.

This QAI observed a welder, Brian Moore, of AB performed fit-up and weld 180 x 80 mm post base plates and 1/4" x 36 mm diameter end cap plates to handrail frames. Two handrail frames were identified as piece-mark FS12E-H.

The other four handrail frames were identified as piece-mark RL3009B. Welding was performed with Flux Cored Arc Welding (FCAW) with E71T-1C 1/16" diameter filler metal in accordance to WPS # ABM-SAS-08. This QAI verified the dimensions of the handrail frames, base plates, and end cap plates. This reviewed WPS.

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Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	FCAW: fillet weld	ABM-SAS-08	Jim Vanek	260	26.2	17 ipm	N/A	QA randomly verified fit-up, amps, volts. Reviewed wps

Summary of Conversations:

General conversations regarding this CCO.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Bahjat Dahger, 510-577-8250, who represents the Office of Structural Materials for your project.

Inspected By:	Chang,Dan	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
